

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001338**Date Inspected:** 28-Jan-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No			
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No	N/A
				<b>Delayed / Cancelled:</b>	Yes	No	N/A
<b>Bridge No:</b>	34-0006	<b>Component:</b>	Floor Beam				

**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector verified snipe and hold back measurements on Floor Beam FB001-04. The findings are as follows:

Snipe measurements for stiffener plates X2 was 25mm x 25mm, X2F was 22mm x 23mm, and X2H was 23mm x 24mm. Drawings indicate snipe measurements should be 25mm x 25mm. It should be understood that an attempt is being made to measure snipe after welding has been completed 100% accuracy is difficult.

Hold back measurements for weld number 018 - 13mm, 017 - 15mm, 016 - 3mm, 015 - 10mm, 012 - 11mm, and 011 - 10mm. These dimensions correspond to the Y value on drawing on GN3 Detail WT1 which require a dimensions of 13mm  $\pm$  6mm.

Hold back measurements for weld number 002 - X1 = 0mm and X2 = 3mm, 003 - X1 = 2mm and X2 = 8mm, 005 - X1 = 0mm and X2 = 5mm, 006 - X1 = 0mm and X2 = 3mm, 007 - X1 = 2mm and X2 = 2mm, 007 - X1 = 10mm and X2 = 10mm. These dimensions correspond to the X value on drawing GN3 detail WT1 which require a dimension of 6mm  $\pm$  3mm. The X1 dimension recorded is located next to snipe and the X2 dimension recorded is located on the opposite end of snipe.

**Summary of Conversations:**

No conversations spoken.

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## WELDING INSPECTION REPORT

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	McClendon,Timothy
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Cuellar,Robert
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QA Reviewer
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